

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029505**Date Inspected:** 30-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 1300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Bernie Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At Pier 7 warehouse, this QA together with ABF QC Bernie Docena have observed the exploratory excavation of Ultrasonic Testing (UT) detected defect on welded mock up plate ESW #19 Electro Slag Weld (ESW). ABF personnel was observed perform exploratory excavation on welded ESW at location Y=830mm. Prior to the excavation, ABF QC Bernie Docena has performed the UT and confirmed the existence of transverse indication at Y=830mm with depth of 34mm from face 'A' and indication rating of +24db. The ABF personnel have started the exploratory excavation by flush grinding the surface then excavated the weld at 3mm increments. The personnel were noted using only the disc grinder in every 3mm increments of excavation. ABF QC Bernie Docena was observed performing Magnetic Particle Testing (MT) on every depth of excavation with no significant indication noted so far. This QA also performed the same test at every depth and noted same result. During the shift, the ABF personnel continued the excavation in 3mm increments using the same method of test and verification up to 12mm with no significant indication so far. The shift was completed up to this depth of excavation.

The results of the exploratory excavations are as follows;

1. 0mm in depth – no significant indication noted.
2. 3mm in depth – no significant indication noted.

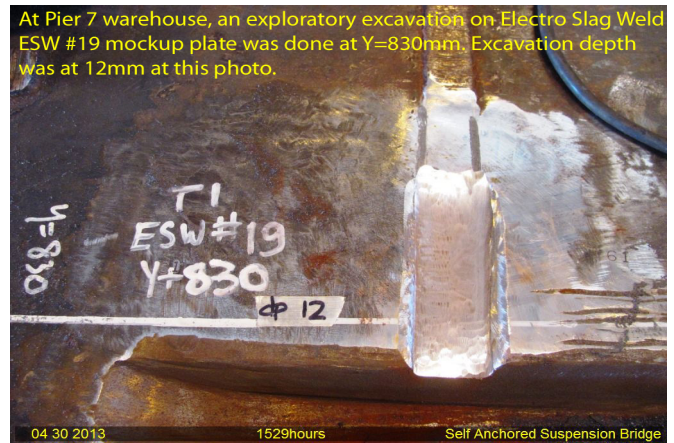
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## WELDING INSPECTION REPORT

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3. 6mm in depth – no significant indication noted.
4. 9mm in depth – no significant indication noted.
5. 12mm in depth – no significant indication noted.



### Summary of Conversations:

No significant conversation occurred today.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas 916-764-6027, who represents the Office of Structural Materials for your project.

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**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

**Reviewed By:** Reyes, Danny

QA Reviewer

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